

M18147

Dart Aerospace Ltd.

Date: Tuesday, 21/10/2008 10:45:18 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLEVIS
Job Number	: 42766		
Estimate Number	: 13301		
P.O. Number	:	Part Number	: D37651
This Issue	: 21/10/2008 S.O. No. :	Drawing Number	: D3765 REVA
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 40971	Material	:
Written By	:	Due Date	: 31/10/2008
Checked & Approved By	: <u>JLD 08-10-21</u>	Qty:	100 Um: Each
Comment	: Est Rev:A New Issue 08-05-05 JLM Verified By:EC Est Rev:B 08-06-17 rev.A as per dwg DD verified by:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0 M6061T6R1000

ROUND BAR 1.00"



(no more mat M18147)



Comment: Qty.: 0.1969 f(s)/Unit Total: 1.9688 f(s)

ROUND BAR 1.00"

Batch:

M18147  $\Rightarrow$  83 parts  $\Rightarrow$  17 ftM101417  $\Rightarrow$  4 ft

SA

08/11/17

2.0 DOOSAN LATHE

DOOSAN LATHE



Comment: Doosan Lathe

1- Turn as per Folio FA744 Rev: N/A & Dwg D3765 Rev: A

2-Deburr per dwg D3765

SA 08/11/17

(100)

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 08/11/17

(100)

4.0 MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1-SLIT PART USING 4" -7/32" WITH .063" RAD SLITTING SAW

2-DEBURR

N/A 08-11-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 21/10/2008 10:45:18 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 42766

Part Number: D37651

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



N/A  
08-11-16

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

inf 08/11/19

(100)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MD

08-11-16

X100

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M.D. 08/11/19

(100)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST249A

JS

08/11/20

(100)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/20

Job Completion



U 08.11.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



8

7

6

5

4

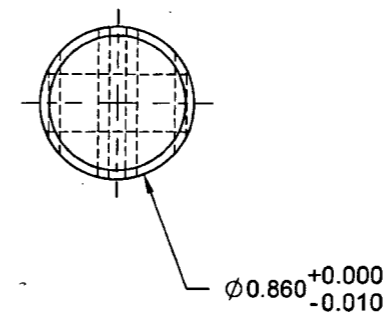
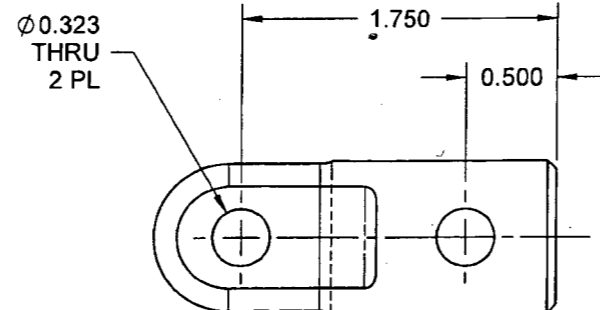
3

2

1

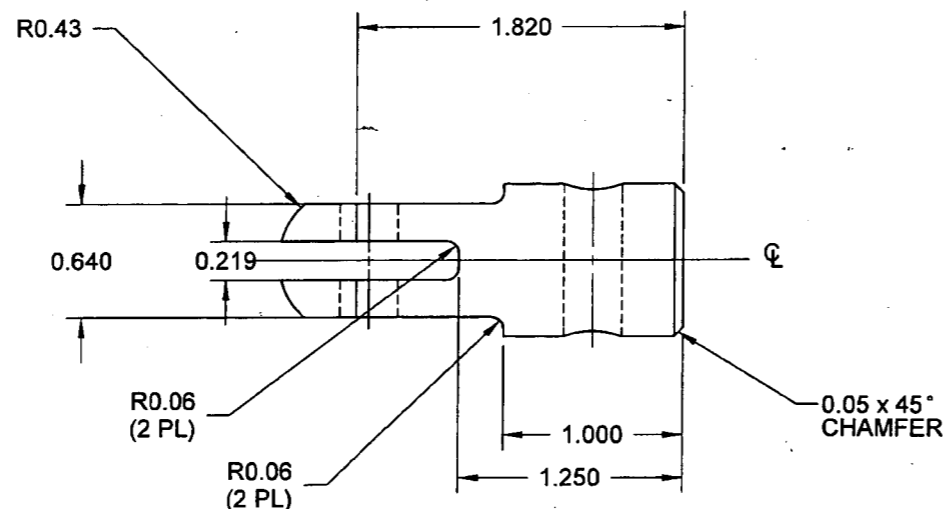
D

D



C

C



### D3765-1 CLEVIS

**RELEASED**  
08.06.16

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42700

#### NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.	HS	D3765	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	CLEVIS	NTS
DATE	08.06.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

A

8

7

6

5

4

3

2

1